

Date: Monday, 26/05/2008 1:12:02 PM
 User: Linda Lacelle

Process Sheet

OK

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : END FITTING ASS'Y
 Job Number : 39485
 Estimate Number : 13345
 P.O. Number :
 This Issue : 26/05/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : / / Type : R & D LG FAB
 Previous Run :
 Written By : M 08/05/20
 Checked & Approved By :
 Comment : Est Rev:A 08-05-20 new issue DD verified by:

Part Number : D3763041
 Drawing Number : D3763 PROTO
 Project Number : IA0004
 Drawing Revision : PROTO 08.05.29
 Material :
 Due Date : 02/06/2008 Qty: 13 Um: Each

Additional Product

PROTOTYPE

Job Number:



FOR ENGINEERING USE ONLY

Seq. #: Machine Or Operation: Description :

1.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
 Pick Packing Kit

2.0 D37631 End Fitting



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
 End Fitting
 batch: 339483

Cpl 08.05.29

X13

3.0 D37633 Tube



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
 Tube
 batch: 339467

Cpl 08.05.29

X13

4.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1
 1-make a 0.063" chamfer on D3763-1 fitting before ass'y
 2-assemble as per dwg D3763 using locating pin DT 9014
 3-weld as per dwg D3763 QSI004
 Alum. rod Batch: M106834

Cpl 08.05.28

X13

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Drawing Name: END FITTING ASS'Y

Job Number: 39485

Part Number: D3763041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC9

VISUAL WELDING INSPECTION



08/05/29

13

Comment: VISUAL WELDING INSPECTION

6.0

QC5

INSPECT WORK TO CURRENT STEP



PRO

**ENGINEERING
APPROVAL**

Comment: INSPECT WORK TO CURRENT STEP

08.05.29

7.0

PACKAGING 1

PACKAGING RESOURCE #1



FOR ENGINEERING USE ONLY

Comment: PACKAGING RESOURCE #1

Identify with Dart part # using a fine point permanent marker and Stock
Location: _____

N/A

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08.06.02

Penotype

Job Completion



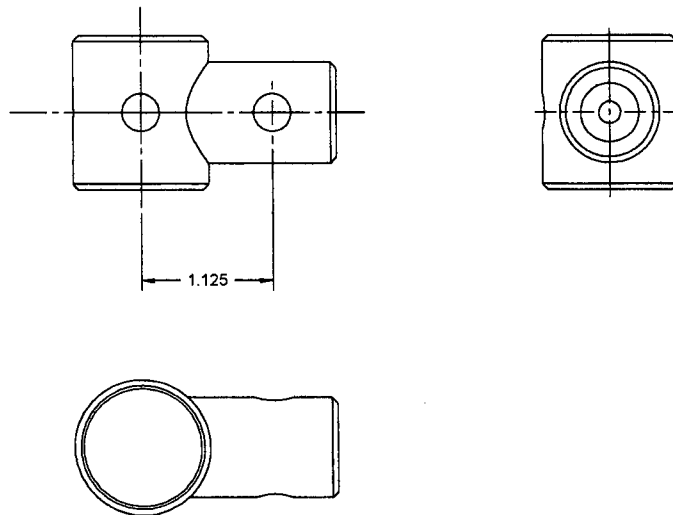
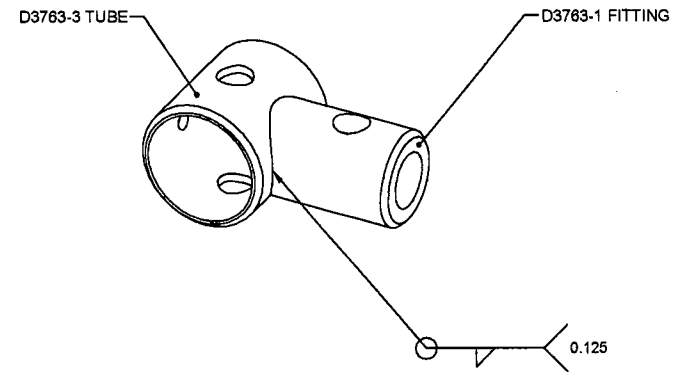
Change to U/I # 0096

08.06.11

5.6 Qc3 FY 08.05.29

5.5 Chemical conversion cost assembly per part 08.05.29

13



D3763-041 END FITTING ASSY

REV 08-05-29
PROTOTYPE

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: ~~NONE~~ **CHEMICAL CONVERSION COAT ASSEMBLY PER QSI 005 4.1**
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.03 lbs
- 8) WELD: PER DART QSI 004

REV.	DESCRIPTION	BY	DATE
DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	HS		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3763	SHEET 1 OF 7
APPROVED		TITLE	SCALE
DE APPR.		END FITTING	NTS
DATE	08.05.22	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	